

THAT WHICH IS CLAIMED:

1. A method of forming a coated SBS board product, comprising:
precalendering a SBS board product with a surface conditioning device
comprising a heatable counter-roll disposed adjacent to a tubular flexible
jacket extending around a fixed support element and having a load
5 element disposed therebetween for biasing the flexible jacket against the
counter-roll, the flexible jacket having opposed ends and being mounted to
at least one end wall at each end, the flexible jacket and the at least one
end wall at each end being rotatably driven by a drive mechanism
operably engaged therewith, the SBS board product being directed
10 between the flexible jacket and the counter-roll so as to be precalendered
thereby, the SBS board product having a top side, a back side, and being
formed without being processed by either of a Yankee dryer and a wet-
stack calender, the SBS board product further comprising a plurality of
fiber plies, including outermost plies forming the top and back sides and
15 comprised of bleached chemical pulp, and medial plies disposed between
the outermost plies and comprised of at least one of pulp and broke; and
coating the top side of the SBS board product at least once, following
precalendering thereof, such that the coated SBS board product has a
density of between about 500 kg/m^3 and about 1000 kg/m^3 , and a basis
20 weight of between about 150 g/m^2 and about 400 g/m^2 , and the top side of
the coated SBS board product has a PPS-s10 roughness of between about
 $0.5 \mu\text{m}$ and about $2.0 \mu\text{m}$ and a Hunter gloss of between about 40% and
about 80%.

2. A method according to Claim 1, wherein coating the top side of the SBS
board product further comprises coating the top side of the SBS board product without
coating the back side thereof.

3. A method according to Claim 1 further comprising coating the back side of the SBS board product at least once.

4. A method according to Claim 1, wherein coating the top side of the SBS board product further comprises coating the top side of the SBS board product in a coating process such that the coated SBS board product has a basis weight of between about 180 g/m² and about 350 g/m².

5. A method according to Claim 1, wherein coating the top side of the SBS board product further comprises coating the top side of the SBS board product in a coating process such that the coated SBS board product has a basis weight of between about 180 g/m² and about 300 g/m².

6. A method according to Claim 1, wherein coating the top side of the SBS board product further comprises coating the top side of the SBS board product such that the top side thereof has a Bendtsen roughness of between about 0 ml/min and about 50 ml/min.

7. A method according to Claim 1, wherein coating the top side of the SBS board product further comprises coating the top side of the SBS board product such that the top side thereof has a Bendtsen roughness of between about 0 ml/min and about 20 ml/min.

8. A method according to Claim 1, wherein coating the top side of the SBS board product further comprises coating the top side of the SBS board product such that the top side thereof has a PPS-s10 roughness of between about 0.8 μm and about 1.5 μm.

9. A method according to Claim 1, wherein coating the top side of the SBS board product further comprises coating the top side of the SBS board product such that the top side thereof has a Hunter gloss of between about 45% and about 65%.

10. A method according to Claim 1, wherein coating the top side of the SBS board product further comprises coating the top side of the SBS board product such that the coated SBS board product has a density of between about 750 kg/m³ and about 1000 kg/m³.

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11. A method according to Claim 1 further comprising calendering the SBS board product with a calender following precalendering of the SBS board product, the calender being selected from the group consisting of at least one nip and a soft calender.

10 12. A method according to Claim 1, wherein precalendering the SBS board product further comprises moistening at least one of the top side and the back side of the SBS board product.

15 13. A method according to Claim 1, wherein precalendering the SBS board product further comprises precalendering the SBS board product without moistening either side thereof.